

Date: Tuesday, 09/10/2007 2:55:12 PM
User: Linda Lacelle

Process Sheet

Split - (4) 1/2

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
Job Number : 35030 - 2
Estimate Number : 12882
P.O. Number : N/A
This Issue : 09/10/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL / MED FAB
Previous Run : 35030
Part Number : D3560042
Drawing Number : D3560 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 19/10/2007 Qty: 10 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev: A New Issue 07.05.24 EC
est rev B ECN 987 07.10.09 EC verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 14.6475 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: B10595

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: A & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35030

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE

3 34478

07-11-08

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch ()
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-13 (4)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-11-08 (4)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-11-14

07-11-14

4X
V4

Date: Tuesday, 09/10/2007 2:55:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35030

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-11-14

(4)

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Spacer B 35330

mf 07-11-15

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Press bushing in D3560 arm per dwg D3562

mf 07-11-15

(4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-15 (1)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 152

(4)

AS 07/11/15

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/15 (4)

Job Completion

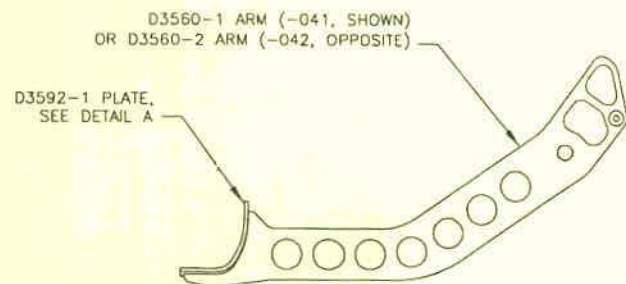


07/11/15

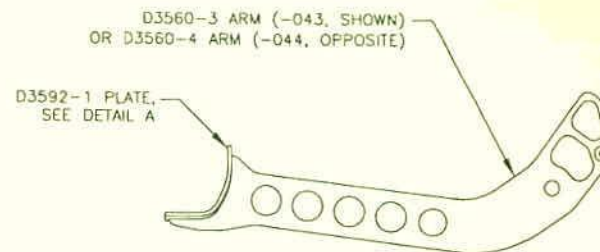
1873-1874

1873-1874

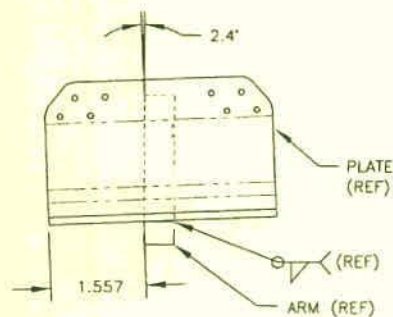
1873-1874



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

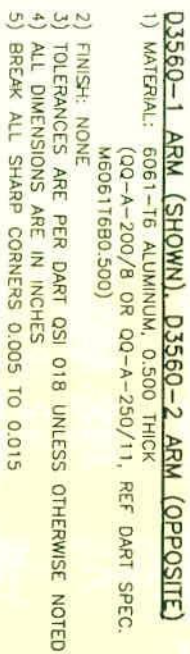
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	07	DRAWN BY 07
CHECKED	07	APPROVED 07
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4

NO. 35030
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

Handwritten musical notation on a single staff, including a treble clef, a key signature of one sharp (F#), and a 2/4 time signature. The notation consists of several measures of music, with some notes and rests visible. The handwriting is in ink on aged, slightly discolored paper.

Handwritten musical notation on a single staff, continuing from the previous section. It includes a treble clef, a key signature of one sharp (F#), and a 2/4 time signature. The notation shows several measures of music, with notes and rests clearly visible. The paper is aged and shows some staining.



SCALE 1:1



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

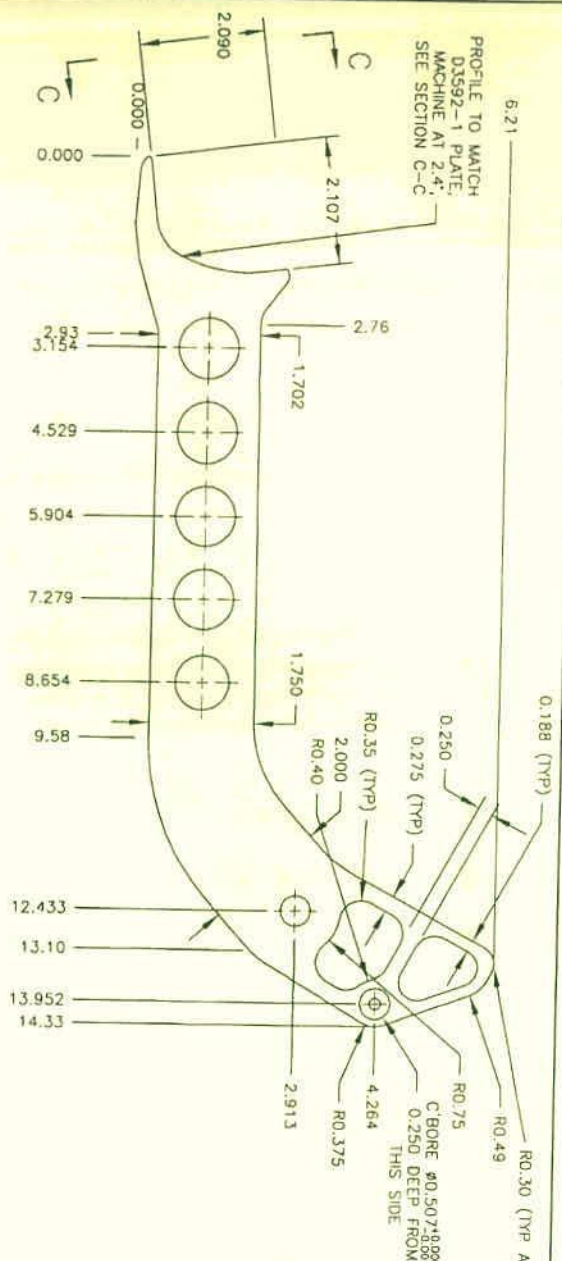
DESIGN	00	DRAWN BY	00	DART DART AEROSPACE LTD. Mississauga, Ontario, Canada
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	
DATE	07.06.19	DRAWING NO.	D3560	
		TITLE	ARM WELDMENT	
				REV. C SHEET 2 OF 3 SCALE 1:2

1:2

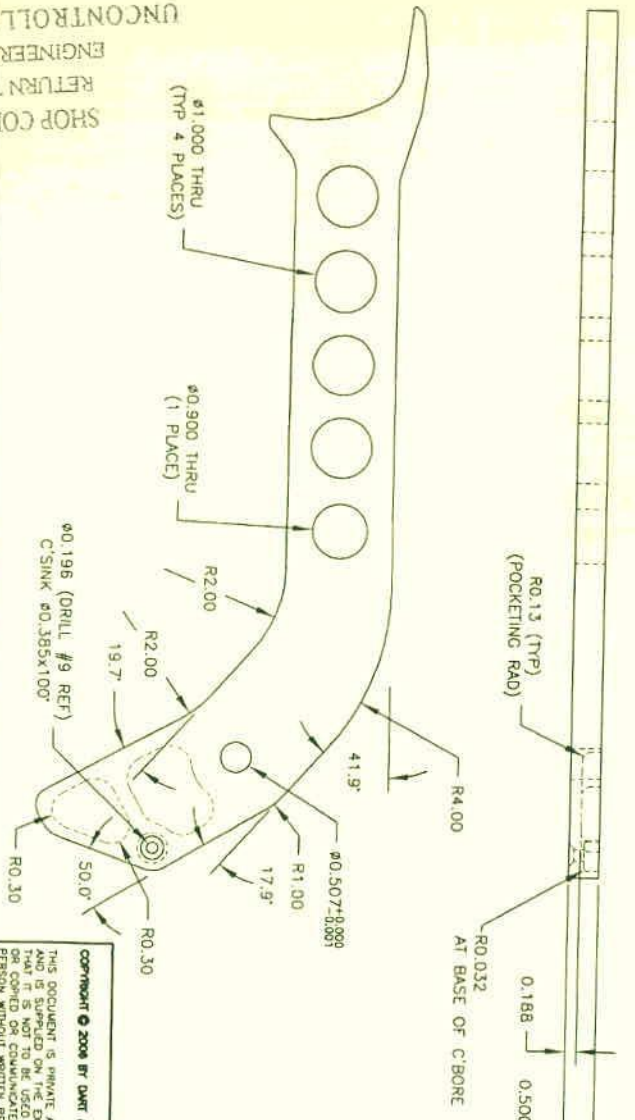
NO. 55030
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

00.196 (DRILL #9 REF)
C'SINK 00.385x100'

NO. 35030
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
VIEW ROTATED
SCALE 1:1

RELEASED
07.06.19

COMMENT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	Q7	DRAWN BY	Q7	DART	DART AEROSPACE LTD.
CHECKED	Q7	APPROVED	Q7	DART	DART AEROSPACE LTD.
DATE	07.06.19	TITLE	ARM WELDEMENT	REV. C	SHEET 3 OF 3
					SCALE

